

Work Order ID 85546

June-11-12 9:55:29 AM

85546

Page 1

Item ID: D3848-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gasket

Start Date: 08/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3848	B
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100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3848

Recut

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-6-13

Jm 12-6-19

Pho ->

12-6-13

W/O: 85346		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3848-7 PAR #: _____ Fault Category: Small Fab / water jet NCR: (Yes) No DQA: John Date: 12/06/27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 12/6/27

NCR: 12-1523		WORK ORDER NON-CONFORMANCE (NCR) 10.83						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/13	#100	Found QH #1 Part that is cut too short. P.C. Sheets of Rubber didn't cut lap. operator didn't base enough mat. Operator Error SET-UP	S 05/04/12 12/06/13	SCRAP DESTROY AND Rehe. B 122112 04	12/26/13 Jm 12-6-19	S 12/06/20	S 05/04/12 12/06/13	S 12/06/13

NOTE: Date & initial all entries

Work Order ID 85546

85546

Page 2

June-11-12 9:55:29 AM

Item ID: D3848-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 08/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Salva/20

(77)

Quality Control

130

Identify as per dwg & Stock Location: FG

0.00

130

Packaging

Memo

0.00

7

12/06/2012

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

12/06/2012

Quality Control

MLJ 12/06/2012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-11-12 9:55:32 AM

Page 1

Work Order ID: 85546

85546

Parent Item: D3848-7

D3848-7

Parent Item Name: Gasket

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	286.1429	2.886	12.82667			

MNEO60S 063

**

HB-6-13

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

286.142884

120948

286.142884

120948

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

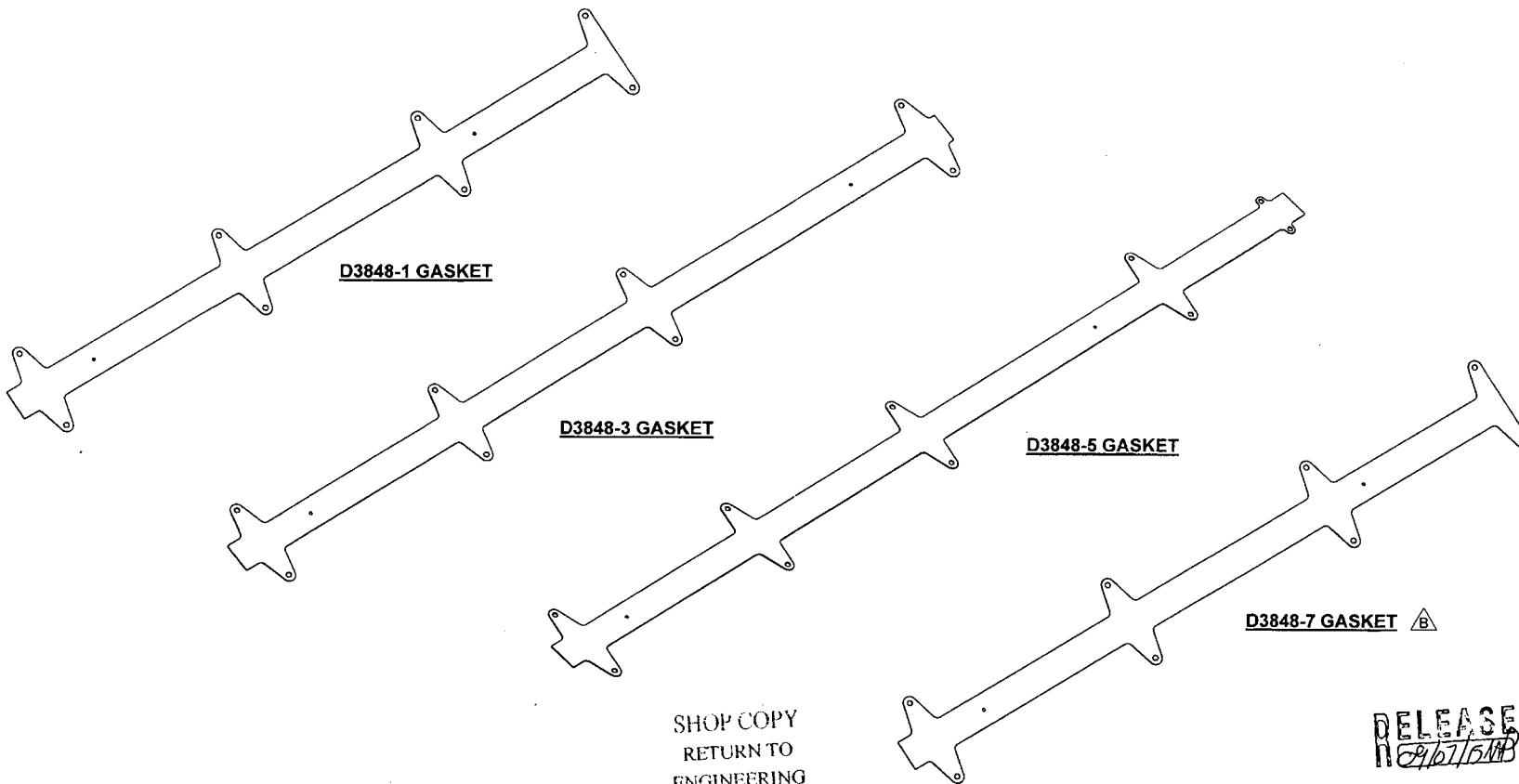
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D3848-1 GASKET

D3848-3 GASKET

D3848-5 GASKET

D3848-7 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 85546 MLJ
12/06/01

RELEASED
29/07/01

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3848-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:
D3848-1 = 0.36 lbs
D3848-3 = 0.44 lbs
D3848-5 = 0.51 lbs
D3848-7 = 0.36 lbs

B	RE-DESIGN Ø0.400 WAS SLOT HOLE ON D3848-1/-3/-5 (ZN C4-2, A4-2, A8-2, C4-3, A7-3); ADD D3848-7 (ZN B2-1 & A4-3); 66.67 WAS 67.36 (ZN B4-2)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<u>RF</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>RF</u>	D3848	SHEET 1 OF 3
APPROVED	<u>RF</u>	TITLE	SCALE
DE APPR.	<u>RF</u>	GASKET	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

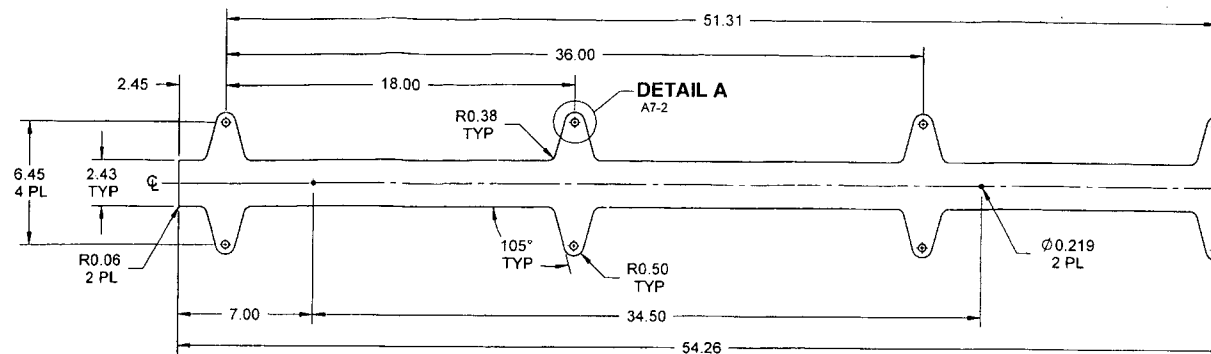
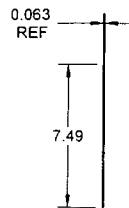
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

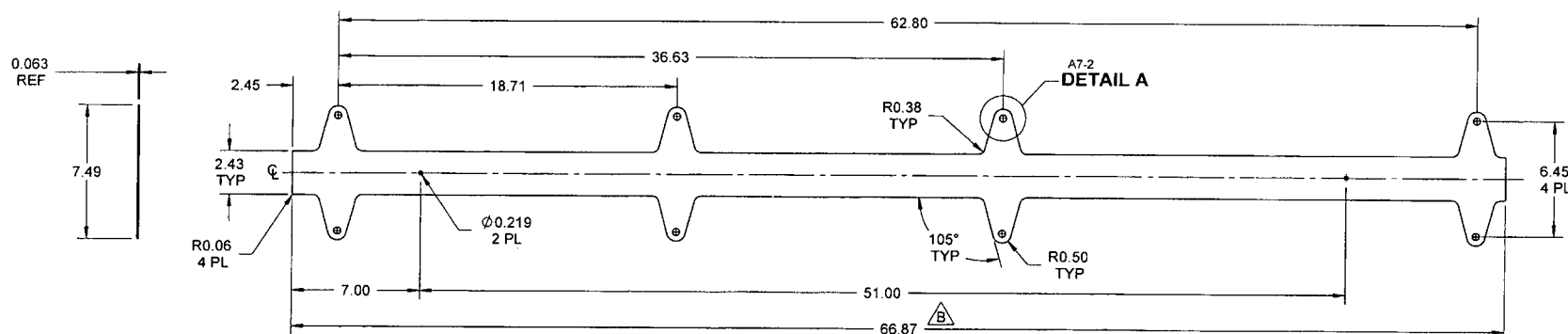
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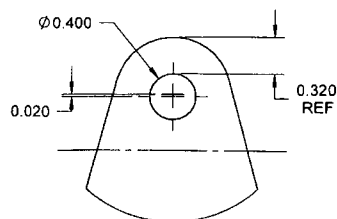
NOTE: Date & initial all entries



D3848-1 GASKET



D3848-3 GASKET



DETAIL A: SLOT DETAIL
TYP

D4-2
C3-2
D2-3
B3-3

RELEASED
8/27/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3848	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
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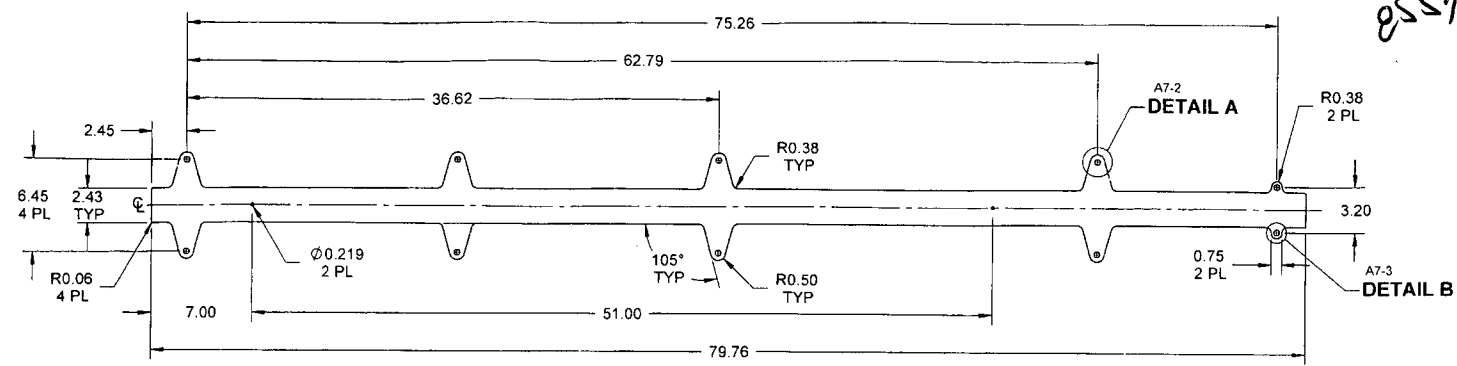
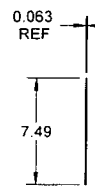
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

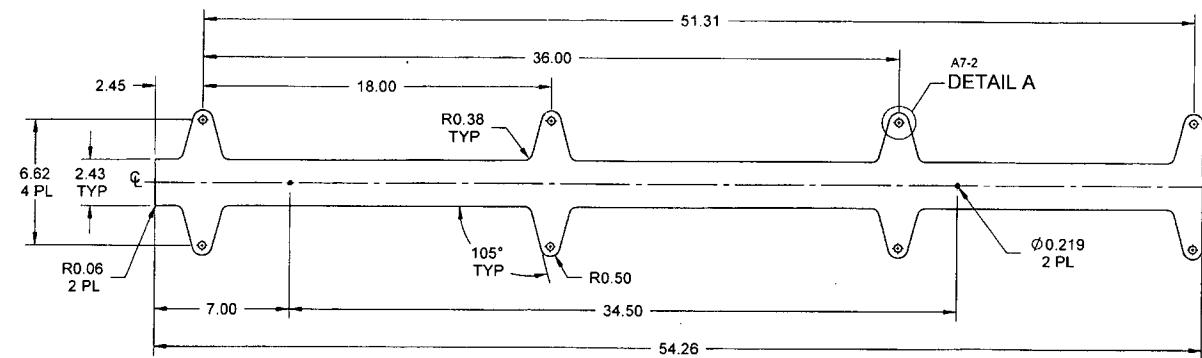
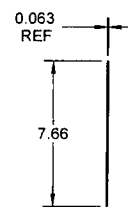
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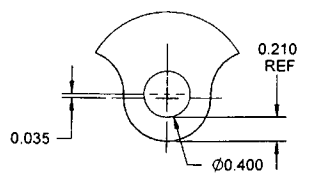
85546



D3848-5 GASKET



D3848-7 GASKET



DETAIL B: SLOT DETAIL C1-3
TYP

RELEASED
8/17/13

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3848	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GASKET	NTS
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